

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 145250

145250

Page 2

Thursday, May 05, 2016 9:22:34 AM

Item ID: D3018-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Cushion
 Start Date: 5/6/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/20/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo *****REMOVE "CHESTNUT FOAM" LABEL AND ATTACH TO WORK ORDER FOR TRACEABILITY*****	0.00 0.00				(4)			DAS 38 9-89 JUN 01 2016
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>SH45</u> Memo	0.00 0.04				4			DAS 6 9-89 JUN 01 2016
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40							1606.07 RYNA / HJ MCS JUN 01 2016

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Picklist Print

Thursday, May 05, 2016 9:22:40 AM

Page 1

Work Order ID: 145250

145250

Parent Item: D3018-1

D3018-1

Parent Item Name: Seat Cushion

Start Date: 5/6/2016

Required Date: 5/20/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B01.06.08Removed acid etch & alodine EC
11.08.08 added note per NCR 11-588 DD VERF:EC IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3018-1P		Purchased	No			110	Each	0.0000	1	4			
D3018-1P Seat Cushion									**  <u>24</u> <u>16-05-30</u>				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

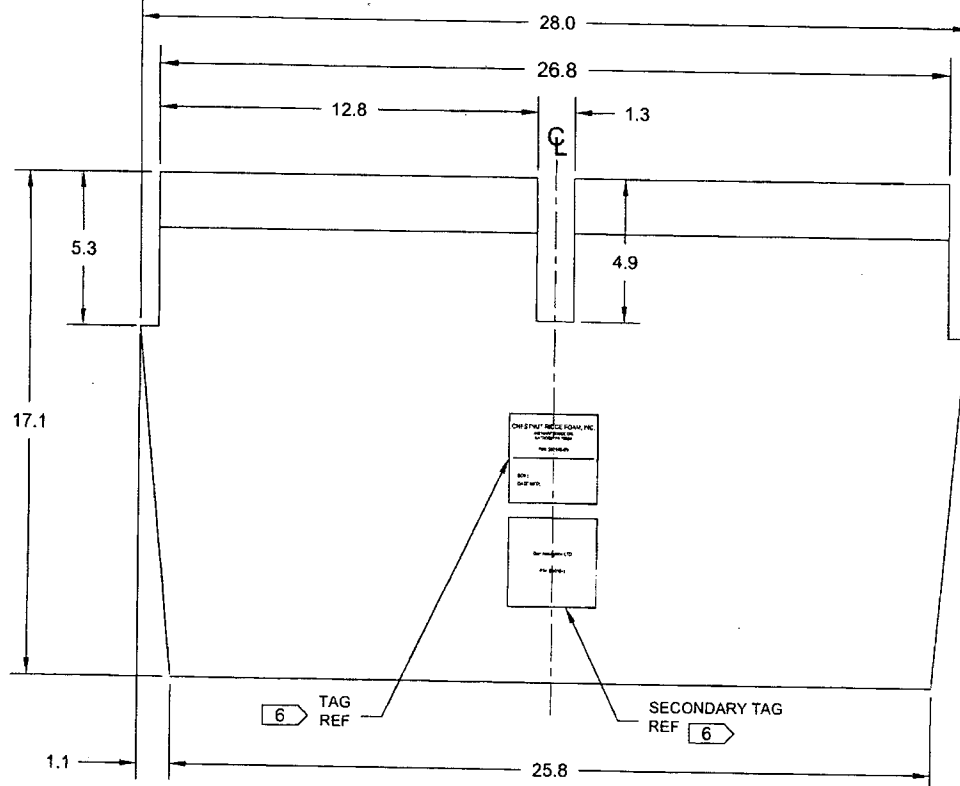
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING

TABLE 1									
THICKNESS/ HEIGHT	TOLERANCE		LENGTH/ DEPTH	TOLERANCE		WIDTH (LEFT TO RIGHT)	TOLERANCE		
(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)
0.0 - 0.50	0.05	0.05	0.00 - 6.00	0.05	0.05	0.00 - 6.00	0.05	0.05	
0.51 - 1.00	0.13	0.05	6.01 - 12.00	0.13	0.13	6.01 - 12.00	0.13	0.13	
1.01 - 3.00	0.13	0.05	12.01 - 24.00	0.25	0.25	12.01 - 24.00	0.25	0.25	
3.01 +	0.19	0.13	24.01 +	0.50	0.38	24.01 +	0.50	0.38	



D3018-1 SEAT CUSHION

NOTES:

- 1) MATERIAL: MUST MEET FAR 27.853(a) OR 25.853(a)
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 55-65 (COLOUR ORANGE)
DENSITY 3.6 lb/ft³
- 2) FINISH: NONE
- 3) TOLERANCES: PER TABLE 1
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

- 6) IDENTIFICATION: TAG(S), BURNED, TO SHOW THE FOLLOWING AT MINIMUM:
CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
SO#
DATE MFD:
DART AEROSPACE LTD. P/N D3018-1
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE
- 8) MAKE PER TEMPLATE
- 9) POSSIBLE SUPPLIER: CHESTNUT RIDGE P/N 502148-99

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ATTENDANCE
WITHOUT NOTICE
WORK ORDER

NO. 145-250 HCS
16-05-05

RELEASED
R 2011-05-10

B	UPDATE TO CURRENT STD; DRAWING REVISED IAW CHESTNUT RIDGE MFG DWG. REF: NCR11-588	MB	11.05.10
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3018
TITLE SEAT CUSHION
REV. B
SHEET 1 OF 1
SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32295**

Purchase Order Date 5/9/2016 9:12:07 AM
PO Print Date 5/9/2016

Page Number 1 of 2

Order From :

VU-CHE001

CHESTNUT RIDGE FOAM, INC.
PO BOX 6015
HERMITAGE, PA 16148
US

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 09 2016

Contact Name
Vendor Phone 724 537 9000

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3018-1P AS PER DWG D3018 REV. B B145250	Seat Cushion	5/30/2016 Yes 5/30/2016		4.00 Each	\$60.40	\$241.60
Line Total:							\$241.60
2	D3019-1P AS PER DWG D3019 REV. B B145252	Back Cushion	5/30/2016 Yes 5/30/2016		4.00 Each	\$46.77	\$187.08
Line Total:							\$187.08

Note:

5/9/2016

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

Phone: 724-537-9000
Fax: 724-537-9003



Pack Slip: 67760

Packing Slip

Page: 1 of 1

Ship To: Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ON K6A 1K7
Canada

Phone: 613-632-3336
Fax: 613-632-1053

Sold To: Chantal Lavoie Fax#: 613-632-1053
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ON K6A 1K7
Canada

Phone: 613-632-3336
Fax: 613-632-1053

Ship Date: 5/26/2016
Ship Via: FedExInt-NextDay

F.O.B. Origin

PO Line	Part Number/Description Planned Qty	Shipped Qty	Rev	PO Line
---------	--	-------------	-----	---------

Sales Order: 55310

Your PO: PO32295

Salesperson: Matt Gurgiolo

Customer requests a 5-27-16 ship date.

Certificate of Conformity that all components comply with 14CFR 25.853(a) 12 Second Vertical Burn with Shipment.

Line 1 Rel 1

D3018-1P

AIRFLEX Bottom Cushion
4.00 EA

4.00 EA

Our Part: 502148-99

Line 2 Rel 1

D3019-1P

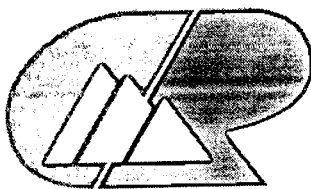
AIRFLEX Back Cushion
4.00 EA

4.00 EA

Our Part: 601988-99

SP/6-05-30

CONTACT CHESTNUT RIDGE FOAM IF THERE IS DAMAGE OR DISCREPANCIES 724-537-9000



Chestnut Ridge
Foam, Inc.

**"URGENT! FLAMMABILITY CERTIFICATION
ENCLOSED. PLEASE FORWARD TO
PURCHASING. DO NOT THROW AWAY!"**

Certificate of Conformance

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury
Ontario CANADA K6A 1K7

PURCHASE ORDER: PO32295

SALES ORDER: 55310

DATE SHIPPED: 05/26/2016

***I certify that the individual components comprising the part shipped
against the above-referenced purchase order meets the following
requirements:***

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	CRF Part Number	Material	Batch Number
4	D3018-1P	502148-99	CR AIRFLEX (55-65)	AF16015
4	D3019-1P	601988-99	CR AIRFLEX (30-40)	AF16003, AF16012

MADE IN THE U.S.A

**Robin
Meighen**

Digitally signed by Robin
Meighen
DN: cn=Robin Meighen,
o=Chestnut Ridge Foam, Inc.,
ou=Sr. Q.A. Inspector,
email=rmeighen@chestnutridgef
oam.com, c=US
Date: 2016.05.26 11:55:56
-04'00'

❖ 443 Warehouse Drive Latrobe, PA 15650
❖ Phone: 724-537-9000 Fax: 724-537-9003

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 16058
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF16015
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : CR AIRFLEX 55-65, 1/2 inch thickness
CRF P/N:

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

CONDITIONING STARTED : DATE : 5-3-16
TIME : 10:00 AM

TEST STARTED : DATE : 5-4-16
TIME : 10:50 AM

RESULTS :

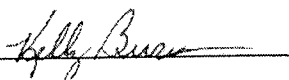
	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	6.8
#2.	0.0	0.0	6.5
#3.	0.0	0.0	6.5
AVG.	0.0	0.0	6.6

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 15953
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF16003
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : CR AIRFLEX 30-40, 1/2 inch thickness
CRF P/N:

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : GREEN

CONDITIONING STARTED : DATE : 1-27-16
TIME : 8:00 AM

TEST STARTED : DATE : 1-28-16
TIME : 9:00 AM

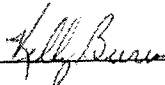
RESULTS :	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	4.2
#2.	0.0	0.0	3.8
#3.	0.0	0.0	4.1
AVG.	0.0	0.0	4.0

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 16031
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF16012
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : CR AIRFLEX 30-40, 1/2 inch thickness
CRF P/N:

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : GREEN

CONDITIONING STARTED : DATE : 4-8-16
TIME : 12:30 PM

TEST STARTED : DATE : 4-11-16
TIME : 7:10 AM

RESULTS :

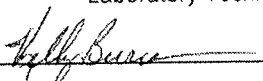
	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	3.8
#2.	0.0	0.0	4.3
#3.	0.0	0.0	4.1
AVG.	0.0	0.0	4.1

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 15917
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : TICKING FR 4440 FABRIC
BATCH / LOT NO. : 1680
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : SUPPLIED BY: HANES CONVERTING CO. OF CONOVER, NC
ON INVOICE #62-166404

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : NA

MATERIAL PATTERN : WOVEN

MATERIAL COLOR : TAN

CONDITIONING STARTED : DATE : 12-28-15
TIME : 11:00 AM

TEST STARTED : DATE : 1-4-16
TIME : 9:15 AM

RESULTS :

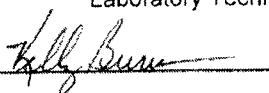
	FLAME TIME (SECONDS)		DRIPPINGS (SECONDS)		BURN LENGTH (INCHES)	
	WARP	FILL	WARP	FILL	WARP	FILL
#1.	0.0	0.0	0.0	0.0	4.0	4.4
#2.	0.0	0.0	0.0	0.0	4.3	4.5
#3.	0.0	0.0	0.0	0.0	4.1	4.5
AVG.	0.0	0.0	0.0	0.0	4.1	4.5

PASS : X FAIL:

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853.
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



CHESTNUT RIDGE FOAM, INC.

443 WAREHOUSE DR.
LATROBE, PA 15650

P/N: 502148-99

SO# : **55310**

DATE MFD: **05/16**



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